



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D3565-1
Job Sheet 190177



Part No: D3565-1

Job Qty: 8 pcs

Part Name: Wearplate



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/5/19

Job Tracking No:

Due Date: 2/22/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV C IPP Rev :A New Issue 07-01-16 JLM IPP rev B revB dwg 07.04.18 ec IPP Rev:C rev.c as per dwg 08-01-14 DD verified by: IPP Rev: D QC5 added to step 8 08.12.22 KJ Verified by:

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	8 pcs	2/22/19	2/22/19	0.00	0.56	Waterjet - Flow		02-19/03/12
120	QC 8	8 pcs	2/22/19	2/22/19	0.00	0.00	QC 8 - 12		
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 38		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
130	Large Fab - Welded Assy-2-B4B	8 pcs	2/22/19	2/22/19	0.00	7.14	Large Fab - 1 - B4B		
							Large Fab - 10 - B4B		
							Large Fab - 2 - B4B		
							Large Fab - 3 - B4B		
							Large Fab - 4 - B4B		
							Large Fab - 5 - B4B		
							Large Fab - 6 - B4B		
							Large Fab - 7 - B4B		

MAR 27 2019
DAS 40
9-89

Plex 2/5/19 1:57 PM Dart.lajeunesse.marie

				Large Fab - 8 - B4B	
				Large Fab - 9 - B4B	
140 QC 9	8 pcs	2/22/19	0.00 0.00	QC 9 - 10	
				QC 9 - 18	DAS
				QC 9 - 24	24
				QC 9 - 43	9-89
				QC 9 - 50	
				QC 9 - 9	
150 QC 5	8 pcs	2/22/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	DAS
				QC 5 - 38	24
				QC 5 - 42	9-89
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
160 Powdercoat - 3 Grey Sand - B4B	8 pcs	2/22/19	0.00 0.15	Powdercoat - 1 - B4B	
				Powdercoat - 2 - B4B	
				Powdercoat - 3 - B4B	
				Powdercoat - 4 - B4B	
170 QC 3	8 pcs	2/22/19	0.00 0.00	QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 26	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 38	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 6	
				QC 3 - 68	
				QC 3 - 9	DAS
180 Packaging 3-1 - Stock - B4B	8 pcs	2/22/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	DAS
				Packaging 3 - 6 - B4B	28
				Packaging 3 - 7 - B4B	9-89
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	

					Packaging 3 - 10 - B4B						
					Packaging 3 - 11 - B4B						
					Packaging 3 - 12 - B4B						
					Packaging 3 - 13 - B4B						
					Packaging 3 - 14 - B4B						
					Packaging 3 - 15 - B4B						
					Packaging 3 - 16 - B4B						
					Packaging 3 - 17 - B4B						
					Packaging 3 - 18 - B4B						
					Packaging 3 - 19 - B4B						
					Packaging 3 - 20 - B4B						
					Packaging 3 - 21 - B4B						
					Packaging 3 - 22 - B4B						
					Packaging 3 - 23 - B4B						
					Packaging 3 - 24 - B4B						
					Packaging 3 - 25 - B4B						
					Packaging 3 - 26 - B4B						
					Packaging 3 - 27 - B4B						
					Packaging 3 - 28 - B4B						
					Packaging 3 - 29 - B4B						
					Packaging 3 - 30 - B4B						
					Packaging 3 - 31 - B4B						
					Packaging 3 - 32 - B4B						
					Packaging 3 - 33 - B4B						
					Packaging 3 - 34 - B4B						
					Packaging 3 - 35 - B4B						
					190 QC 21 - SA	8 pcs	2/22/19	0.00 0.00	QC 21 - SA - 21	DAG	MAY 23 2019
									QC 21 - SA - 70	21	
									QC 21 - SA - 53	9-89	
					Part Op 120 - (QC8- Inspect parts - second check) Descriptions: 130 - (Weld per dwg A/R S.S. rod Batch: _____) 140 - (QC9- Inspect visual per QSI004- Fusion Welds) 150 - (QC5- Inspect part completeness to step on W/O) 160 - (Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3) 170 - (QC3- Inspect Part Finish) 180 - (Identify as per dwg & Stock Location: _____) 190 - (QC21- Final Inspection - Work Order Release)						

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3009-3	Cup	24 pcs (3 ea)	100-Waterjet - Flow - 1	5152146
M304S16GA	304/316 Sheet .063	1.0800 sf (.135 ea)	130-Large Fab - Welded Assy-2- B4B	10-128814 12-18521

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	D3009-3	24	70	0
130-Large Fab - Welded Assy-2- B4B	M304S16GA	1	16	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Wearplate(R44)	0.879inches + 0.010 - 0.001	0.889 0.878		
2	Wearplate(R44)	0.750inches ± 0.030	0.780 0.720		
3	Wearplate(R44)	1.000inches ± 0.030	1.030 0.970		
4	Wearplate(R44)	2.000inches ± 0.030	2.030 1.970		
5	Wearplate(R44)	2.250inches ± 0.010	2.260 2.240		
6	Wearplate(R44)	8.120inches ± 0.010	8.130 8.110		
7	Wearplate(R44)	9.620inches ± 0.030	9.650 9.590		
8	Wearplate(R44)	0.063inches ± 0.010	0.073 0.053		

Plex 2/5/19 1:57 PM Dart.lajeunesse.marie

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By _____ Lead hand / Supervisor _____ QC / QA Coordinator _____	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
		Other/Details:			



Container No: S162051



Part: D3565-1

Job No: 190177

Serial No/Batch: S162051

Revision: C

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 813 632-6200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 03/13/19